

Work Order ID 61216 - 2

Wednesday, August 11, 2010 10:23:06 AM

SP1.7



Page 1

Item ID: D3065-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg Assembly Hi

10

Start Date: 8/12/2010 Start Qty: 40.00



Cust Item ID:

Required Date: 9/2/2010 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 10-8-11

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3065 and Identify as D3065-041

8/5/09/30 (10x)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 10/10/01

(10)

120

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

R 10.p.01

10 d

Work Order ID 61216

Wednesday, August 11, 2010 10:23:06 AM

Page 2

Item ID: D3065-041

Accept

Revision ID:

Item Name: Step Leg Assembly Hi

Start Date: 8/12/2010 Start Qty: 40.00

Required Date: 9/2/2010 Req'd Qty: 40.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/10/04
MF
10-10-04

Picklist Print

Wednesday, August 11, 2010 10:23:05 AM

Page 1

Work Order ID: 61216

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi



Start Date: 8/12/2010

Required Date: 9/2/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RE

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3065-1



Step Spacer

Manufactured

No

100

Each

70.0000

1

40

Location

Loc Qty

Loc Code

GA

52

59860

52

WA

18

58210

18

D3065-3



Step Spacer

Manufactured

No

100

Each

71.0000

1

40

Location

Loc Qty

Loc Code

GA

14

59853

14

WA

57

48113

10

60312

47

D3065-5



Step Leg

Manufactured

No

100

Each

81.0000

2

80

Location

Loc Qty

Loc Code

GA

81

59851

1

60311

80

Handwritten notes:

8/30/09/30
~~BG1416~~ (10x)
~~30 29~~
 BG1416 (10x)
 8/30/09/30
~~BG1415~~ (8x)
 BG1415 (10x)
 8/30/09/30
~~BG1202~~ (57x)
 BG1652 (10x)

Picklist Print

Wednesday, August 11, 2010 10:23:05 AM

Page 2

Work Order ID: 61216

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi



Start Date: 8/12/2010

Required Date: 9/2/2010

Start Qty: 40.00

Required Qty: 40.00

D3065-7

Manufactured No

100

Each

55.0000

1

40



Step Spacer

Location

Loc Qty

Loc Code

GA

55

59854

15

60313

40

MS20470AD4-4

Purchased

No

100

Each

1,945.000

30



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

1940

112314

30

113368

92

115156

1818

ST321

5

114761

5



Handwritten notes:
 EP 5.0/09/30
 3612101 (circled)
 1200 570
 EP 10/09/30
 M115470
 300 (circled)
 756
 115

Wednesday, August 11, 2010 10:23:05 AM

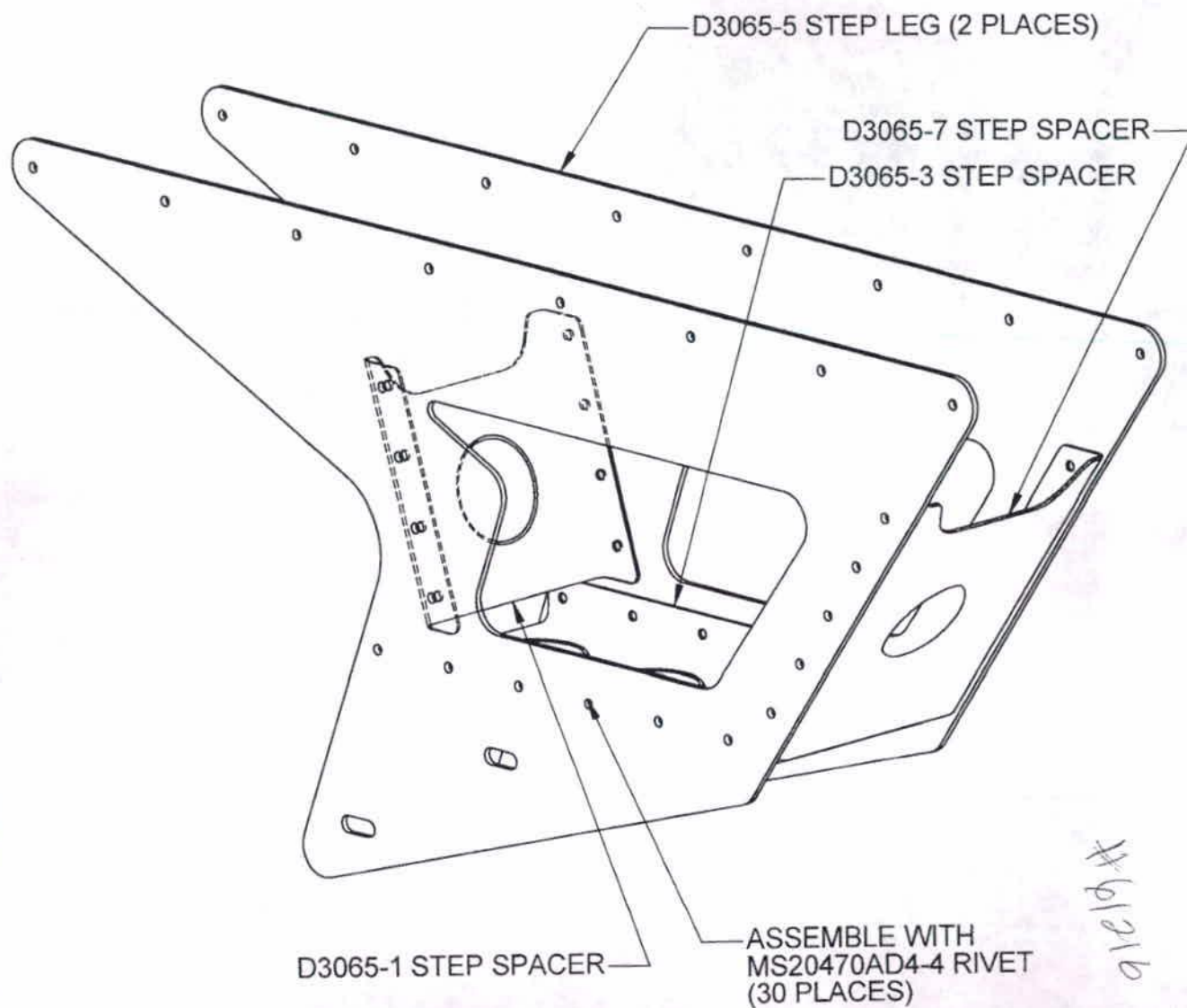
Shop Packet Print

Page 2

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

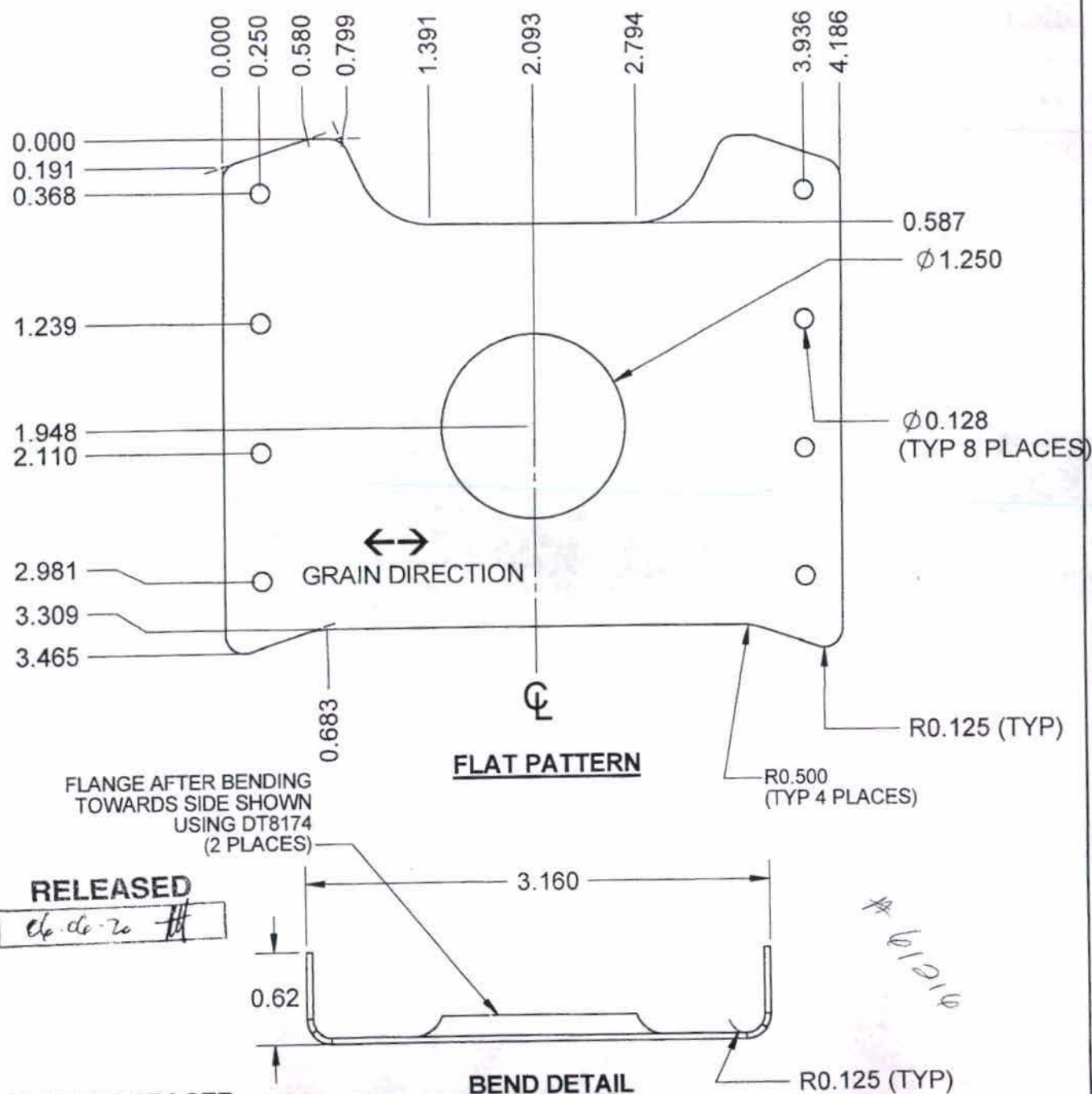
06.06.20 *[Signature]***D3065-041 STEP LEG ASSEMBLY**

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



RELEASED

de de 20 - ~~11~~



D3065-3 STEP SPACER

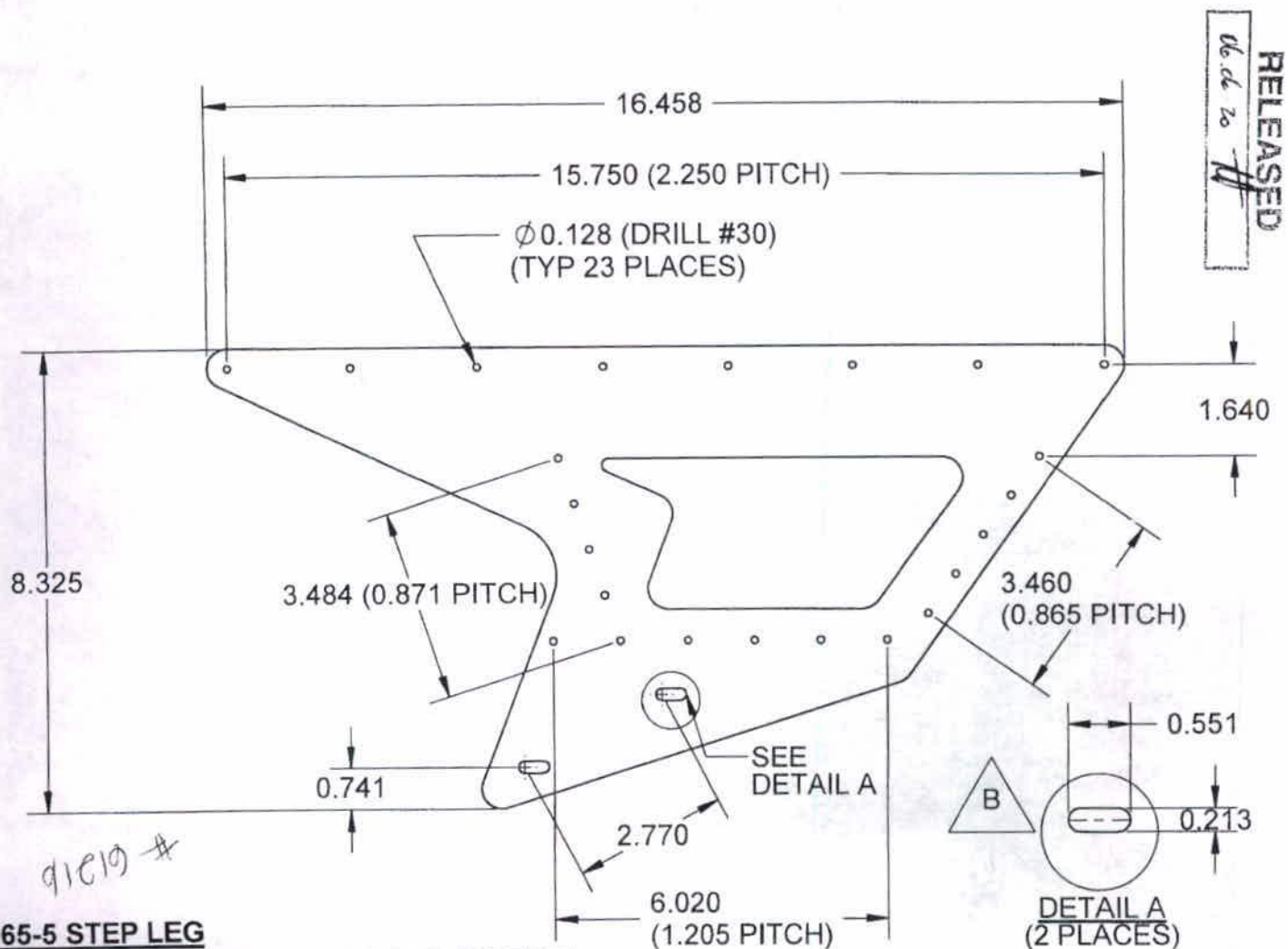
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN	<i>CB</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE LTD
CHECKED	<i>PH</i>	APPROVED	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	DRAWING NO.	D3065	REV. B
		TITLE	STEP LEG ASSEMBLY	SHEET 4 OF 5
				SCALE 1:3

**D3065-5 STEP LEG**

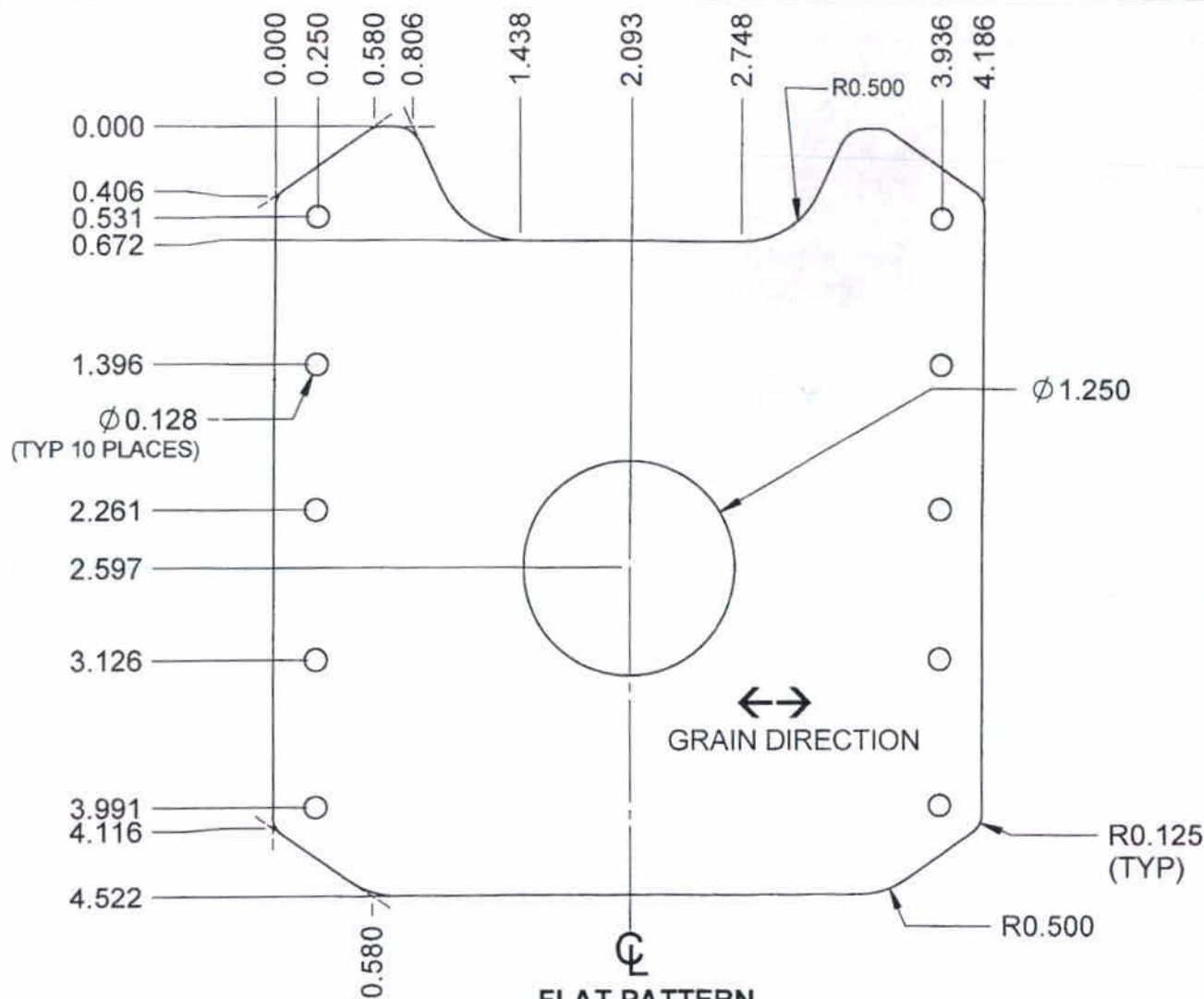
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT ©2002 BY DART AEROSPACE LTD.

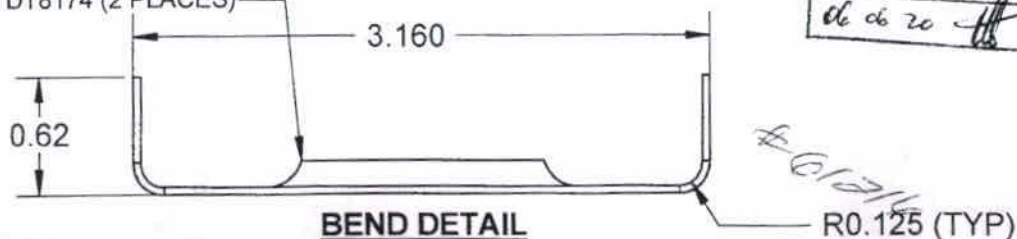
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

**RELEASED***06 06 20***D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2002 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.